

Ship 30/11

48

Date: Monday, 11/19/2007 4:05:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI ACCESS STEP EXT HIGH GEAR
Job Number : 35868	
Estimate Number : 13072	
P.O. Number :	Part Number : D205633023
This Issue : 11/19/2007 S.O. No. :	Drawing Number : DSI 9300 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run :	Material :
Written By : <u>[Signature]</u>	Due Date : 11/29/2007 Qty: 2 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: A new issue Rev B dwg 07-11-19 DD verified by: EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD205-633-023 CHG001

5 07/11/28 07.11.21 [Signature]

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2022101 Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer

Batch: B33985

AS 07/11/21 (2x)

4.0 D2022103 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Batch: B25967

AS 07/11/21 (2x)

5.0 D2562013 Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: B35886

6 07/11/28 (2x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 35868

Part Number: D205633023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2563

Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Weldment Assembly

07/11/28 Batch:

~~B35869~~

B35869

AS 07/11/28 (x2)

7.0

D2565201

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch:

B35115

AS 07/11/21 (2x)

8.0

D2565203

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch:

B35116

AS 07/11/21 (2x)

9.0

D2565205

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch:

B35119

AS 07/11/21 (2x)

10.0

D2565207

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch:

~~B35117~~ B35117

AS 07/11/21 (2x)

11.0

D2565209

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch:

B35118

AS 07/11/21 (2x)

12.0

D3437043

Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Strut Assembly

Batch:

B35872

AS 07/11/27 (x2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 35868

Part Number: D205633023

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	AN45A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100857

KS 07/11/21 (2x)

14.0	AN46A	Bolt
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Batch: M104322

KS 07/11/21 (2x)

15.0	AN47A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M102140

KS 07/11/21 (2x)

16.0	AN412A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M105143

KS 07/11/21 (2x)

17.0	AN414A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M102473

KS 07/11/21 (2x)

18.0	AN44 7A	EYEBOLT
------	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

EYEBOLT

Batch: ~~M105335~~ M105335

*****ENSURE THIS IS AN44-7A EYEBOLT*****

KS 07/11/21 (2x)

19.0	AN514A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M104547

KS 07/11/21 (2x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP EXT HIGH GEAR

Job Number: 35868

Part Number: D205633023

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD416	Washer
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Comment: Qty.: 14.0000 Each(s)/Unit Total : 28.0000 Each(s)
Washer
Batch: M105426

AS

07/11/21

(2x)

21.0	AN960JD516	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)
Washer
Batch: M104156

AS

07/11/21

(2x)

22.0	MS21042L4	Nut
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)
Nut
Batch: M105054

AS

07/11/21

(2x)

23.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Batch: M105430

AS

07/11/21

(2x)

24.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

S

07/11/21 (x2)

25.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-023

Location: D-205

PPP Rev: _____

AS 07/11/21

(+2)

26.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07.11.28

JA

Job Completion



W 07.11.28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 1 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS
A	05.05.05	NEW ISSUE	
B	05.08.12	ADD STRUTS IF TANK REMOVED	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-633 REV. A

REF. CANADIAN STC: SH96-57

REF. FAA STC: SR00592NY, SR00593NY, SR00594NY

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D205-633-021/-022/-023/-024/-025/-026 STEPS TO ADDRESS COMPATIBILITY WITH THE SIMPLEX MODEL 304 FIRE ATTACK TANK. D205-633-021/-022 ARE IDENTICAL TO D205-633-011, EXCEPT AS SHOWN HERE. D205-633-023/-024 ARE IDENTICAL TO D205-633-013, EXCEPT AS SHOWN HERE. D205-633-025/-026 ARE IDENTICAL TO D205-633-015, EXCEPT AS SHOWN HERE.

NOTE THAT THE STRUTS REQUIRED TO INSTALL THE STEPS ON THE LOWER AFT HARDPOINT HAVE ALSO BEEN INCLUDED WITH THE KITS IN CASE THE TANK IS REMOVED FOR ANY REASON. THESE STRUTS SHOULD BE INSTALLED I.A.W. IIN-D205-633, EXCEPT REPLACE EYEBOLT WITH AN4 BOLT ON LOWER HARDPOINT. ALSO NOTE THAT IF THE THREADS PROTRUDE THROUGH THE BAR ON THE D3437-XXX STRUT ASSEMBLIES AFTER ADJUSTMENT THEY MAY BE TRIMMED OFF.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-633-021 <i>HELI-ACCESS-STEP™</i>	14.0 lb 6.35 kg	-50.0 in -1.27 m	-700 in lb -8.06 m kg	94.5 in 2.40 m	1323 in lb 15.24 m kg
D205-633-022 <i>HELI-ACCESS-STEP™</i>	13.2 lb 6.00 kg	+50.0 in +1.27 m	+660 in lb +7.62 m kg	94.5 in 2.40 m	1247 in lb 14.40 m kg
D205-633-023 <i>HELI-ACCESS-STEP™</i>	14.3 lb 6.50 kg	-50.0 in -1.27 m	-715 in lb -8.26 m kg	94.5 in 2.40 m	1351 in lb 15.6 m kg
D205-633-024 <i>HELI-ACCESS-STEP™</i>	13.5 lb 6.14 kg	+50.0 in +1.27 m	+675 in lb +7.80 m kg	94.5 in 2.40 m	1276 in lb 14.74 m kg
D205-633-025 <i>HELI-ACCESS-STEP™</i>	14.6 lb 6.64 kg	-50.0 in -1.27 m	-730 in-lb -8.43 m-k-g	94.5 in 2.40 m	1380 in-lb 15.94 m-k-g
D205-633-026 <i>HELI-ACCESS-STEP™</i>	13.8 lb 6.27 kg	+50.0 in +1.27 m	+690 in-lb +7.96 m-k-g	94.5 in 2.40 m	1304 in-lb 15.05 m-k-g

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BRANCH
DAO # 01-O-01

APPROVED



BY: 
D. SHEPHERD (DE # 02)

DATE: 05.08.12
CERT. NO.: SH96-57
ISSUE NO.: #5

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 2 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS


PARTS LIST

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Hell-Access-Step™ (LH), High Gear
	X					D205-633-022	Hell-Access-Step™ (RH), High Gear
		X				D205-633-023	Hell-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Hell-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Hell-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Hell-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
				*1	*1	D3165-1	STRUT
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

* ONLY INSTALLED IF TANK IS REMOVED

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DAO # 01-O-010. 35868
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BY: 
D. SHEPHERD (DE # 02)
DATE: 05.08.12
CERT. NO.: SH96-57
ISSUE NO.: #5

DART

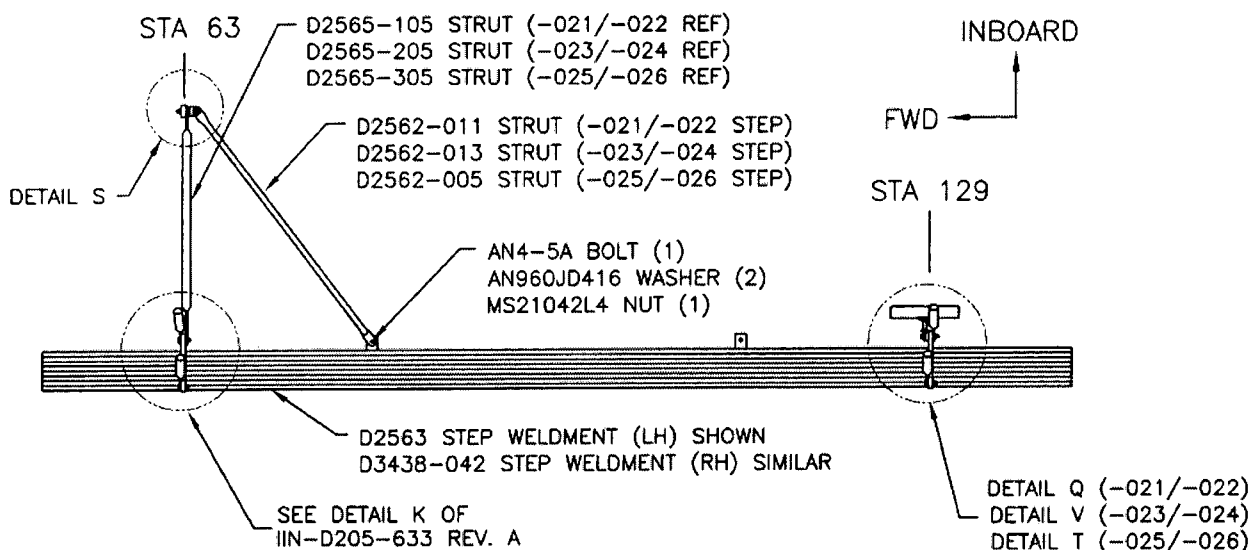
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B 3 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP KIT	SCALE NTS

INSTALLATION OF D205-633-021/-022/-023/-024/-025/-026

INSTALL D205-633-021/-022 AS PER THE D205-633-011 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-111 STRUT WITH THE D3437-041 AFT STRUT ASS'Y, REMOVE D2562-001 STRUT, INSTALL D2562-011 STRUT AS SHOWN.

INSTALL D205-633-023/-024 AS PER THE D205-633-013 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-211 STRUT WITH THE D3437-043 AFT STRUT ASS'Y, REMOVE D2562-003 STRUT, INSTALL D2562-013 STRUT AS SHOWN.

INSTALL D205-633-025/-026 AS PER THE D205-633-015 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D3165-1 SUPPORT ARM WITH THE D3437-045 AFT STRUT ASS'Y AS SHOWN.

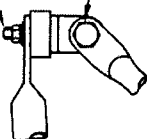


D205-633-021/-023/-025 SHOWN
D205-633-022/-024/-026 SIMILAR
(VIEW LOOKING DOWN)

AN44-7A EYEBOLT (1)
AN960JD516 WASHER (1)
MS21042L5 NUT (1)

AN4-6A BOLT (1)
AN960JD416 WASHER (2)
MS21042L4 NUT (1)

DETAIL S
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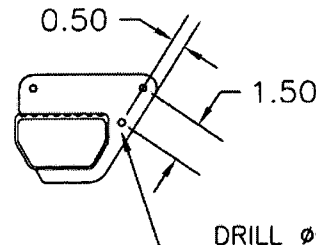
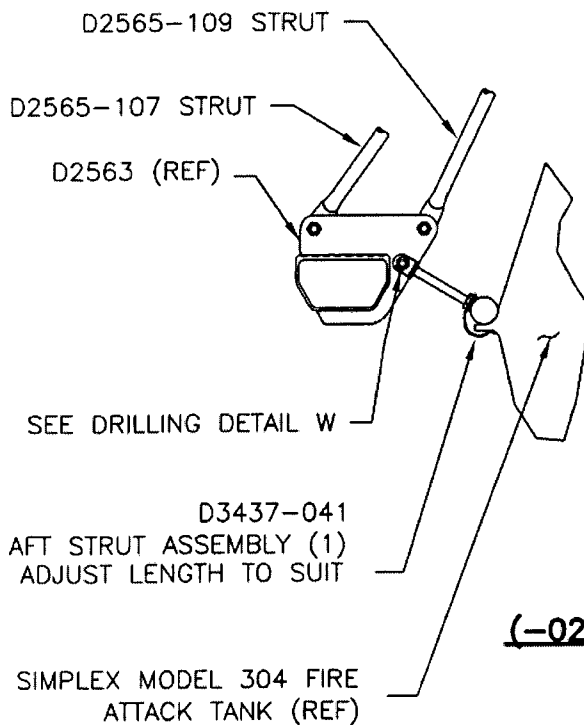
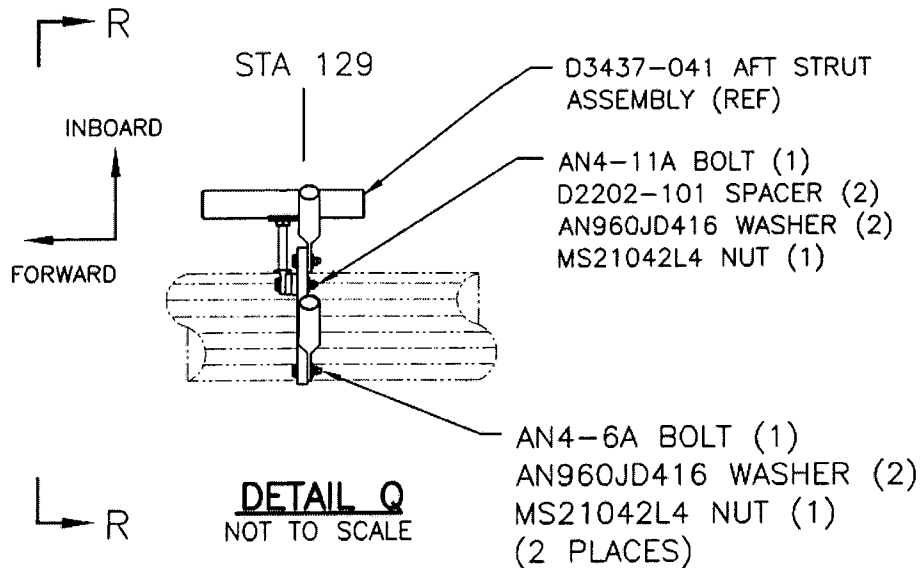
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DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS



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

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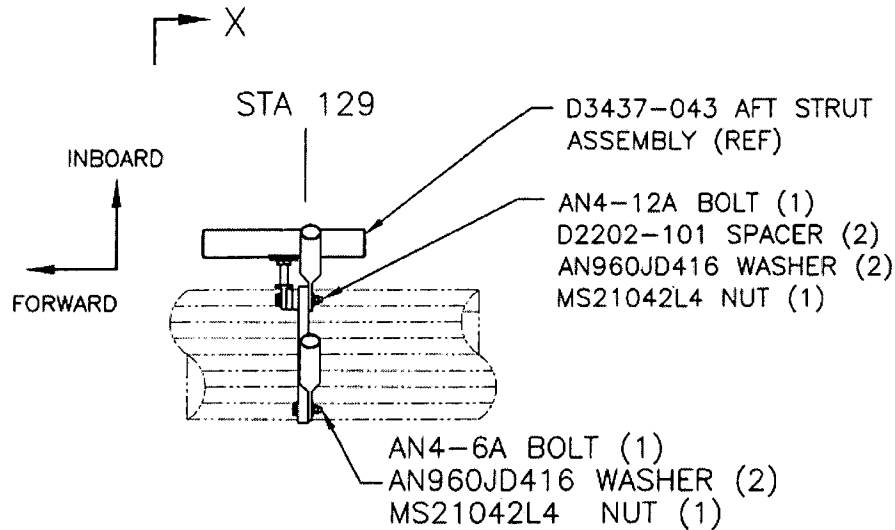
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DATE:	05.08.12
CERT. NO.:	SH96-57
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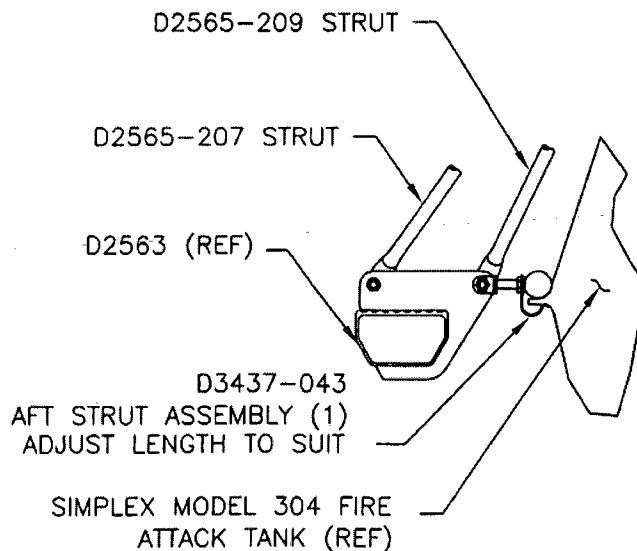
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 5 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS



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(-023/-024 STEP)

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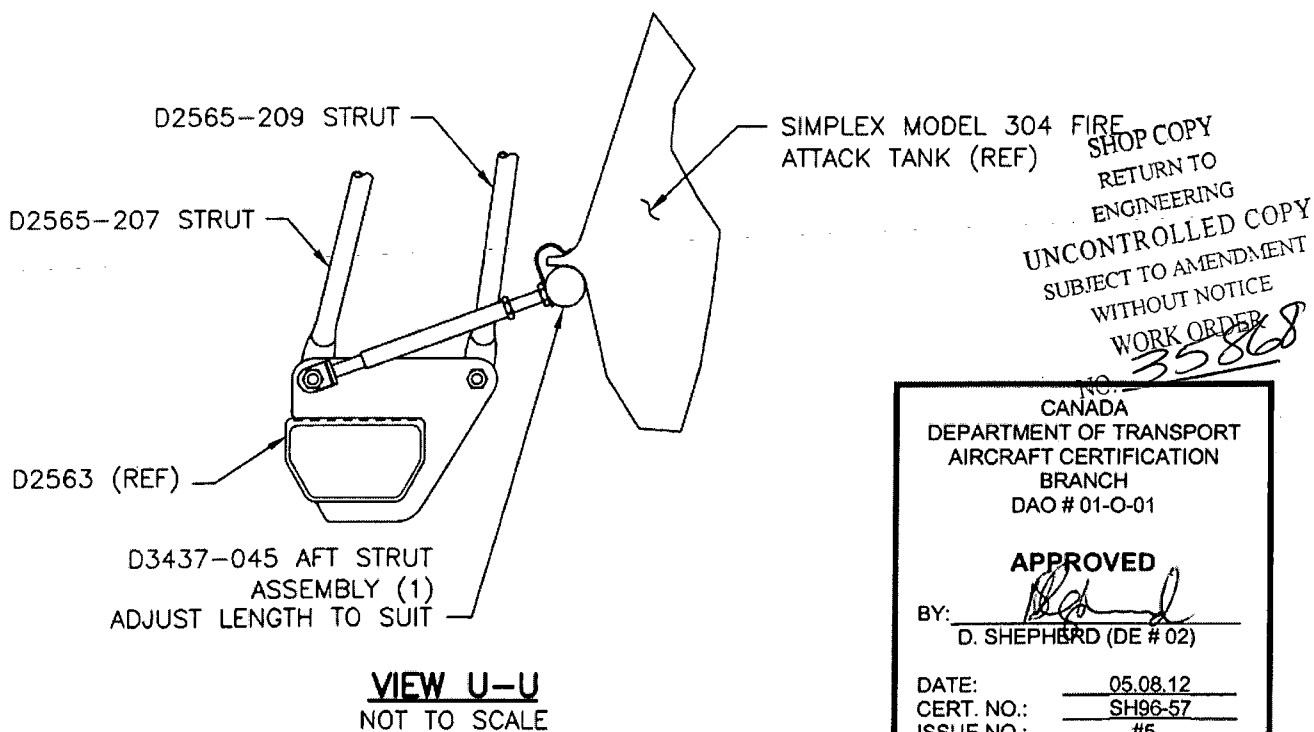
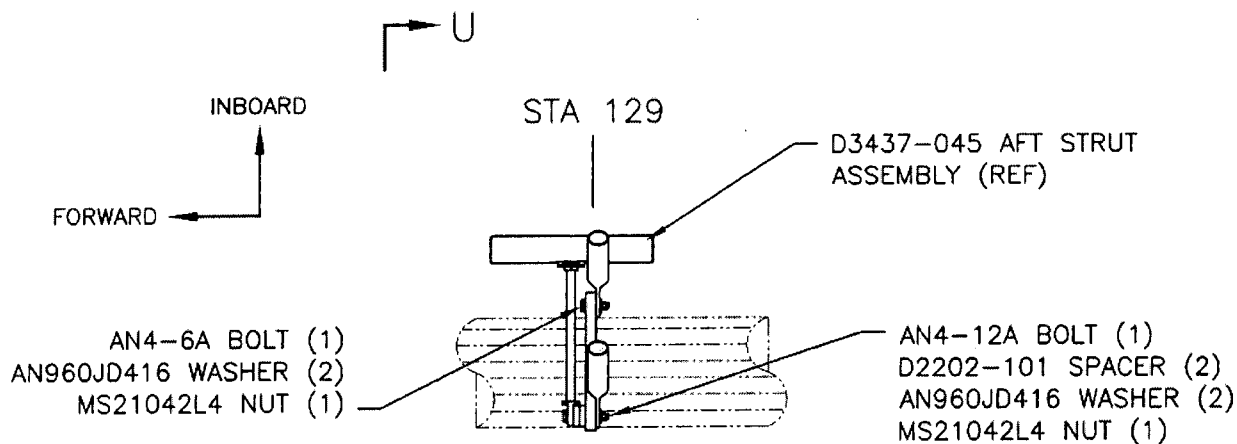
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DATE 05.08.12	TITLE SIMPLEX TANK STEP		SCALE NTS

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Initiator: Jean Kerr
Company: Vector Aerospace
Phone No.: 604-514-5266
Date: March 19/08
Invoice # 5485
Order Entry # 5015
Reason for return: Incorrect steps ordered
Attach Copy of DHS Return Authorization # 387

Receiving: 8/3/08
Date Received: 8/3/08 **Freight Company:** FIDEP **Prepaid** **Collect**

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
2	D205-633-023	35869/36317	Helic Access Steps LH		
2	D205-633-024	36318/35870	" " " RH	<u>NAK</u>	<u>8/3/08</u>

Condition of packaging: Good **Photograph required:** yes ☐ no ☒
Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☐

QC:
Quarantine: **Location:** **Condition of Part:** general
Inspect: **Initial:**

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D205-633-023	36317	restock as per W/O's	<u> </u>	38238	
1	D205-633-023	35869		<u> </u>	38238	
1	D205-633-024	36318		<u> </u>	38246	
1	D205-633-024	35870		<u> </u>	38246	

QA Coordinator:
Advise GM as to findings: **Initial:** **Date:**
Comments:

Issue credit: yes <input type="checkbox"/> no <input type="checkbox"/> GM Approval: <u> </u> Date: <u> </u>	Invoice Amount: <u> </u> Less Replacement: <u> </u> Restock Fee: <u> </u> Freight: <u> </u> Net Credit: <u> </u> DHS <input type="checkbox"/> Customer <input type="checkbox"/>
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QA: Enter into Q-Pulse with reason for return & File original. **Signed:** **Date:**

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit